

Work Order ID 55877

February 3, 2010 1:44:47 PM



Page 1

Item ID: D4014-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Switch Plate

Start Date: 2/03/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/10/10 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals:

Process Plan: *AL*

Date: *10-2-03*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4014

~~A-PRELIM~~ *B*

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *PLT*

Prog Rev: *Lim*

2-Deburr if necessary

SAD 10-02-08

B10-2-4

(2)

(2)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-2-4

~~PRELIMINARY ISSUE~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55877

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Page 2

Item ID: D4014-1

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Setup Start



Revision ID:

Stop



Item Name: Switch Plate

Start Date: 2/03/10

Start Qty: 2.00



Cust Item ID:

Required Date: 2/10/10

Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

⇒ 8044105

Memo

0.00

(12)

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

BR 10-029

Memo

0.00

(2)

P.

151



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

ell 10-02-09

Memo

0.00

START: 11:00AM

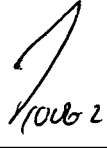
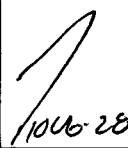
Temp: 320°F

FIN: 11:30AM

(X2)

/

(P10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
100628	151	Add P. casting detail - Start - Temp - Start <i>perm change</i>				 100628	 100628	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55877

February 3, 2010 1:44:47 PM

Page 3

Item ID: D4014-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Switch Plate

Start Date: 2/03/10 Start Qty: 2.00

Cust Item ID:

Required Date: 2/10/10 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: *LA*

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*Re-inspect to Rev B.**2/10/10 (XZ)*

POSITIVE RECALL

EFFECTIVE *11-02-03* AUTH *U*RELEASED *U* DATE *11-08-04**CK 11/08/08**ME 10-2-19*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

February 3, 2010 1:44:50 PM

Work Order ID: 55877



Parent Item: D4014-1

Parent Item Name: Switch Plate

Start Date: 2/03/10

Required Date: 2/10/10

Comments: IPP rev A 09.12.18 new Issue Prelim EC verified: DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	128.6824	0.0140			



6061-T6 Sheet 0.032"



B 10-2-4

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	128.6824	
110063	0.009	
112763	80	
16954	3.28225	
18375	45.39115	

②

16954

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

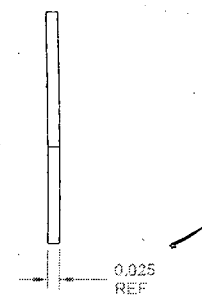
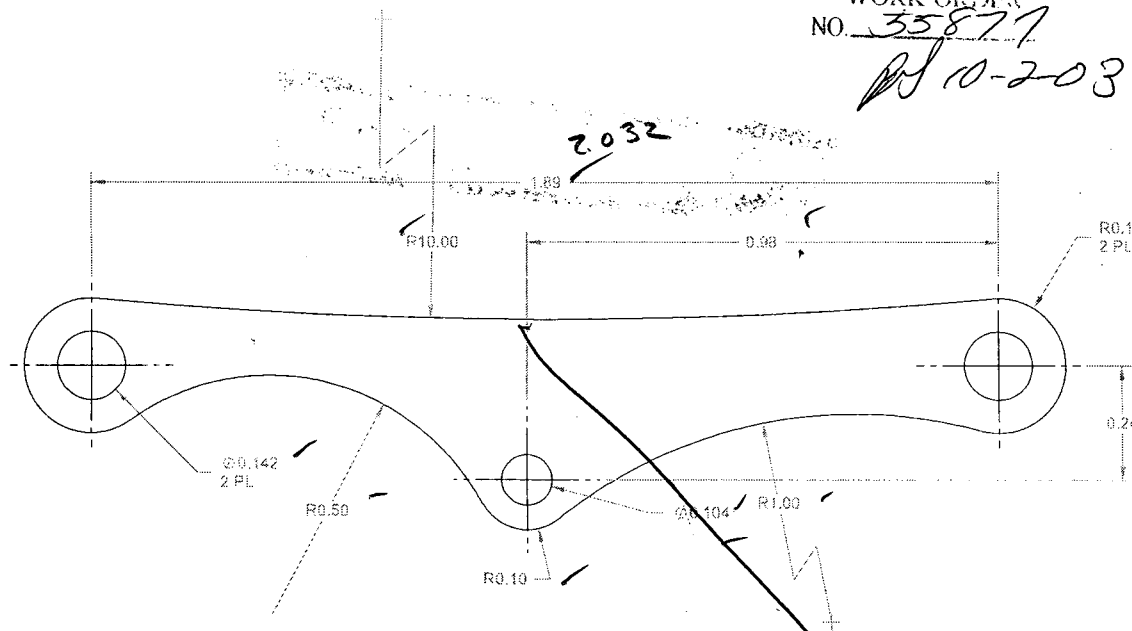
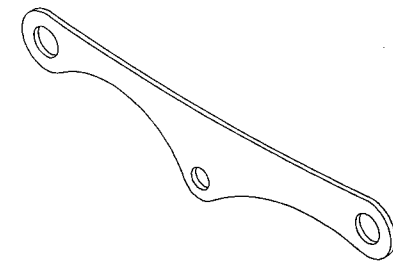
NOTE: Date & initial all entries

42

SHOP COPY

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35877

10-203



D4014-1 SWITCH PLATE

NOTES:

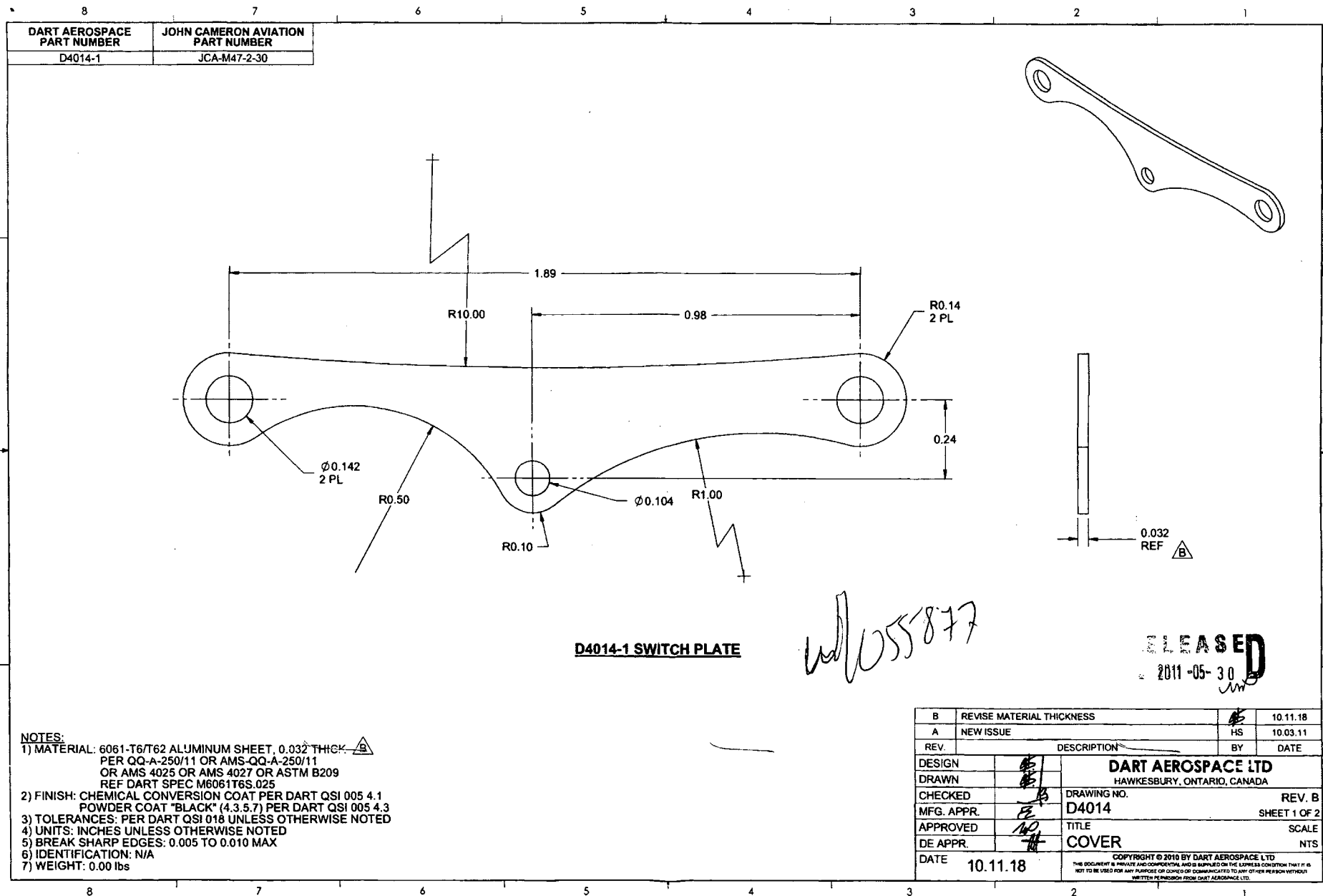
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.025 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.025
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4014-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.00 lbs

0.032"

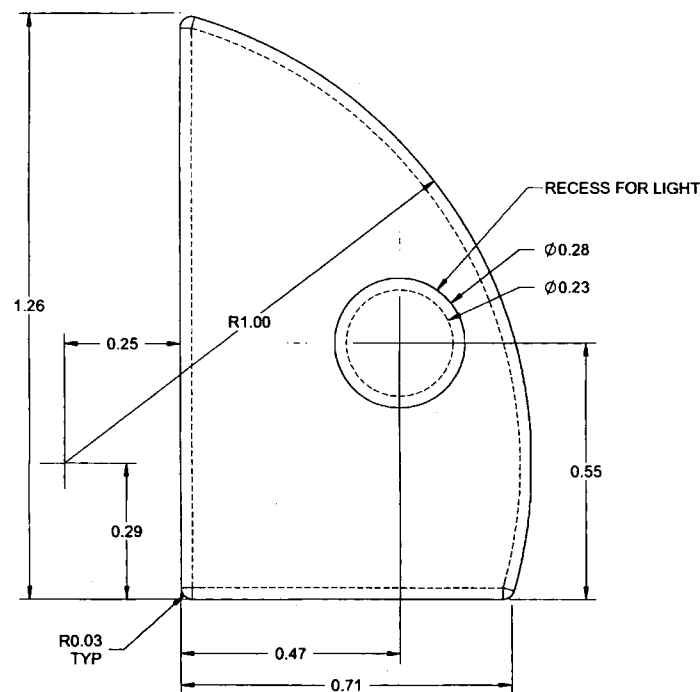
PRELIMINARY ISSUE

09.10.20

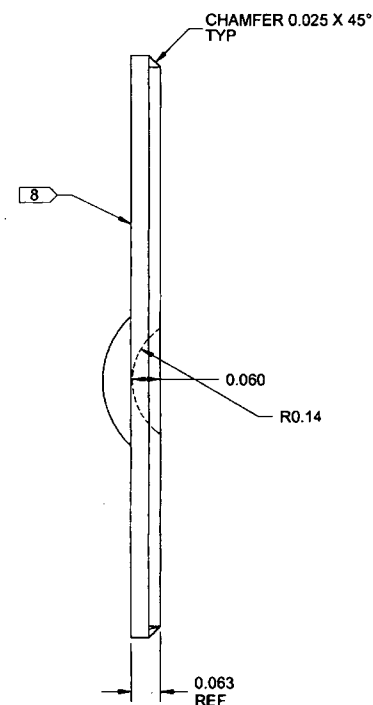
PA1	NEW ISSUE		09.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG APPR.			
APPROVED			
DE APPR.			
DATE	09.10.20		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. PA1 SHEET 1 OF 2 SCALE NTS	
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4014-3	JCA-M47-2-31



D4014-3 GAUGE COVER



NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs
- 8) POWDER COAT THIS SIDE ONLY

DESIGN	1	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1	DRAWING NO. D4014	REV. B
MFG. APPR.	1		SHEET 2 OF 2
APPROVED	1	TITLE COVER	SCALE
DE APPR.	1		NTS
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2011-05-30